

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD				Amendment Design Review (ADR) Yes/No: Yes		ECN #: 865	
Date: 06.11.07				ADR Date: 06.09.26			
Job No: 00075				Created By: <i>UP</i>		Checked By: <i>RLH</i>	
Product No: D412-630				Approved By:		Approved By:	
Product Name: Heli-Access-Step				(Proj. Manager)		(Management if reqd)	
Documents Affected:							
Release:							
-D2804 Rev.C -D412-630 Rev.K							
-D3560 Rev.A -ICA-D412-630 Rev.2							
-D3562 Rev.A -FMS-D412-630 Rev.E							
-D3563 Rev.A							

#	Engineering Actions	Yes	No	Responsible	To happen by:	Complete
1	Required Documents/Drawings Under Review?	X		CP	06.11.10	06.11.07 <i>UP</i>
2	Update Blue/Pink Folder/Electronic File	X		KJ/CP		06.11.09 <i>UP</i>
3	Update DSI Folder/Electronic File		X			
4	Update D-Part Master Binder	X		KJ		06.11.09 <i>UP</i>
5	Update Grey Project Binder	X		CP		06.11.07 <i>UP</i>
6	Update DEO/DSI Binder		X			
7	Update Master Document List (MDL)	X		CP		06.11.07 <i>UP</i>
8	Update Document Record (DR)	X		CP		06.11.07 <i>UP</i>
9	Update Change Record Form	X		CP		06.11.07 <i>UP</i>
10	Move Electronic File	X		KJ		06.11.09 <i>UP</i>
11	Notify TC of Change		X			
12	Notify FAA of Change		X			
13	Update QSI 021 (TC/FAA STC)		X			
14	Update QSI 036 (K-Kits)		X			
15	Update Accpac Database	X		KJ		06.11.07 <i>UP</i>
16	Update Access Database	X		KJ		06.11.07 <i>UP</i>
17	Verification ARC	X		KJ/CP		06.11.07 <i>UP</i>
18	Update STC Approval List		X			
19	Update Product Development Summary		X			
20	Create/Update COSS (Estimate/BOM)	X		JLM/EC		06.11.07 <i>UP</i>
21	Create/Update PPP's	X		KJ/CP		06.11.07 <i>UP</i>
22	Update Paperwork Kits in Production	X		<i>LL KJ</i>		N/A per Bill Beckett # <i>UP</i>
23	Update Paperwork Kits in Stock	X		LL		N/A per Bill Beckett # <i>UP</i>
24	Red Tag Stock with old CHG #	X		<i>DT JH</i>		07.01.17
25	Rework/Scrap Current Production	X		LL		NOT REWORKING <i>UP</i>
26	Rework/Scrap Kits in Stock?	X		LL		See Below <i>UP</i>
27	Update Qpulse/Laminated Dwgs	X		KJ		N/A <i>UP</i>
28	Create/Update Controlled PDF Files	X		KJ		06.11.09 <i>UP</i>
29	Create/Update FAI sheets	X		JLM/EC		<i>UP</i>
30	Create/Update CNC Programs	X		JLM/EC		<i>UP</i>
31	Create/Update Tooling	X		JLM/EC		06.11.11
32	MPP required?		X			
33	Notify Previous Customers	X		DHS <i>SN</i>		07-08-30
34	Notify Eurocopter France		X			
35						
36						

Description / Action:

-D2804-1/-2 has changed, new shape. This should already be reprogrammed as we've made prototypes.

-D3563-10 Eyebolt is a new part, this is a drilled AN43B-10A eyebolt that will now be included in all D412-630-013/-014 kits

-D412-630-033/-034 are two new kits at CHG#001. These are meant to replace D412-630-013/-014/-023/-024.

-D3560-1/-2/-3/-4 Arm are two new parts, for the new -033/-034 steps,

-D3562-041/-042 Step Weldments are the new step for the -033/-034 steps, special tooling will be needed to weld the arms on at an angle

-see attached. **- NOT REWORKING - PEGGY CAN SELL TO CUSTOMERS w/o LIFE RAPT 06.11.30**

ECN Complete: *UP*

Date: 01/04/37

D2803-043/-044 Bracket

- dwg has not changed, but D2803-043/044 should now be obsolete for new kit production. These should only be produced for replacement purposes only. All new kits will use D2803-041/-042.

D2804-1/-2/-041/-042/-043/-044 Bracket

- D2804 now at rev.C
- D2804-1/-2 has been changed, the shape has been slightly altered to provide more clearance
- D2804-043/044 should now be obsolete for new kit production. These should only be produced for replacement purposes only. All new kits will use D2804-041/-042.

D2805-3/-4 Stop

- dwg has not changed, but D2805-3/-4 should now be obsolete for new kit production. These should only be produced for replacement purposes only. All new kits will use D2805-1/-2.

D3563-10 Eyebolt

- new part for -013/-014 step kits.
- basically a drilled/primed AN43B-10A eyebolt

D412-630-011/-012 Kit *3 IN STOCK FOR EACH - NO CHANGE*

- All new kits will have the new D2804-041/042 bracket (new shape). All new kits mfg'd with new bracket are at CHG#005. Existing stock is OK as is.

D412-630-013/-014 Kit *Ø IN STOCK / Ø IN PROD - NO CHANGE*

- D412-630-013/-014 kits are now at CHG#005
- new kits are per parts list in D412-630 Rev.K, update all estimates, main changes are:
 - i) now uses D2803-041/-042 brackets instead of D2803-043/-044
 - ii) now uses D2804-041/-042 brackets instead of D2804-043/-044
 - iii) now uses D3563-10 Eyebolt instead of D2012-107 clevis at hardpoint.
 - iv) some bolts/washers have changed.
- Update all kits in stock to CHG#005:
 - i) replace D2803-043/-044 with D2803-041/-042
 - ii) replace D2804-043/-044 with *new* D2804-041/-042 per D2804 Rev.C
 - iii) replace qty(1) D2012-107 clevis, qty(1) AN4-6A bolt, qty(1) AN4-10A bolt with qty(1) D3563-10 Eyebolt, qty(1) AN4-7A Bolt, qty(4) AN960JD416 Washer
 - iv) replace decals as req'd to reflect new change number
 - v) replace paperwork (IIN/ICA/etc) with new documents.
- This kit should only be produced for special requests or replacement purposes. We should try to sell the new D412-630-033/-034 instead.
- May need hardware kit for customers, these would include:
 - i) LH kits: qty(1) D2803-041, qty(1)*new* D2804-041, qty(1) D3563-10 eyebolt, qty(2) D2022-101 spacers, qty(4) AN960JD416 washers, qty(2) MS21042L4 nuts, *qty(1) AN4-7A* new paperwork, and red decals.
 - ii) RH kits: qty(1) D2803-042, qty(1) *new* D2804-042, qty(1) D3563-10 eyebolt, qty(2) D2022-101 spacers, qty(4) AN960JD416 washers, qty(2) MS21042L4 nuts. *qty(1) AN4-7A* new paperwork, and red decals.

D412-630-023/-024 Kit 15 IN STOCK, 4 IN Prod (B28362) / 13 IN STOCK - NO CHANGE

- All new kits will have the new D2804-041/042 bracket (new shape). All new kits mfg'd with new bracket are at CHG#003. Existing stock is OK as is.
- This kit should only be produced for special requests or replacement purposes. We should try to sell the new D412-630-033/-034 instead.

D412-630-033/-034 Kit

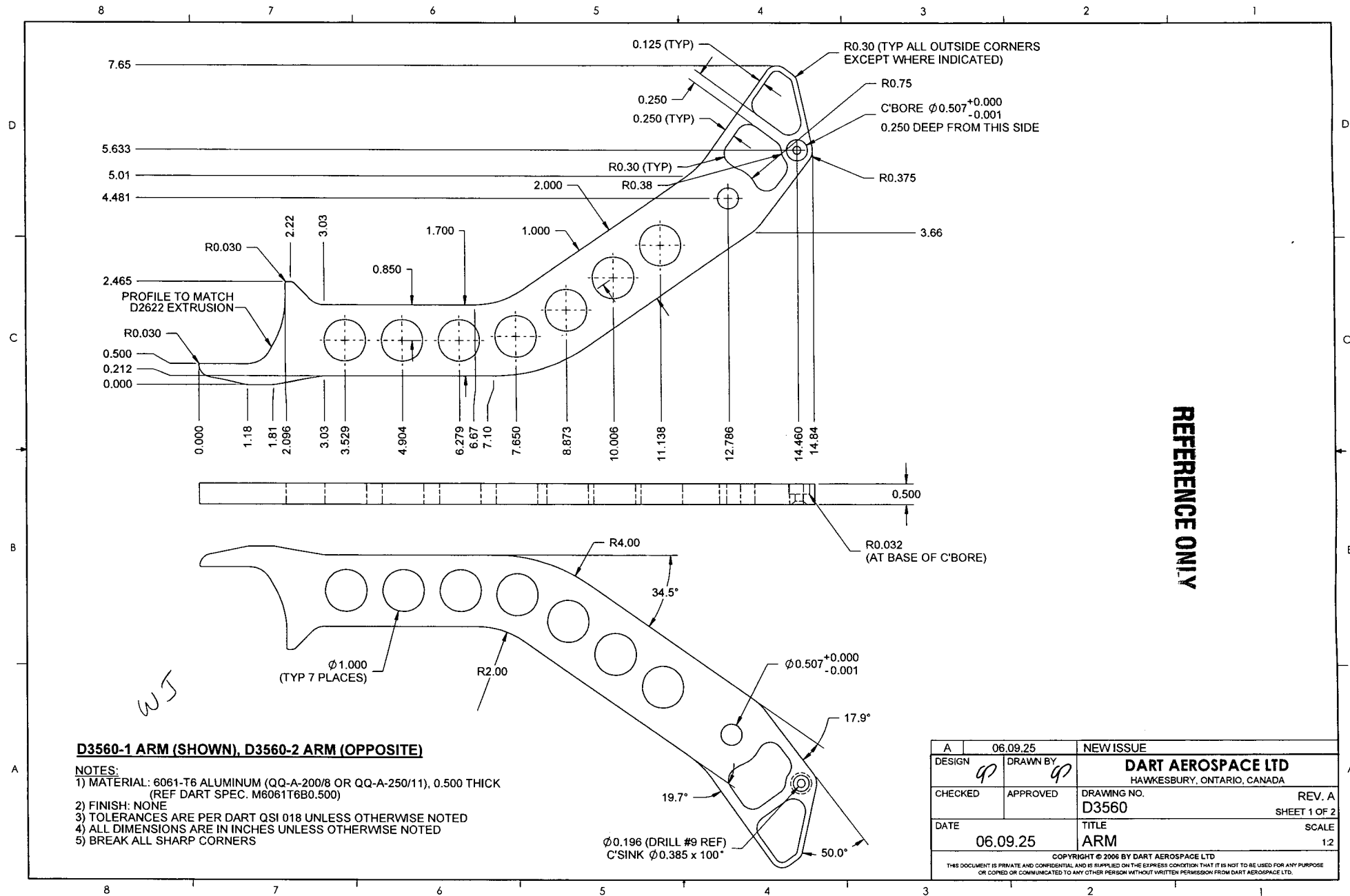
- new kits at CHG#001 ✓
- similar to -023/-024 kit, but has different step weldment (D3562-041/-042)

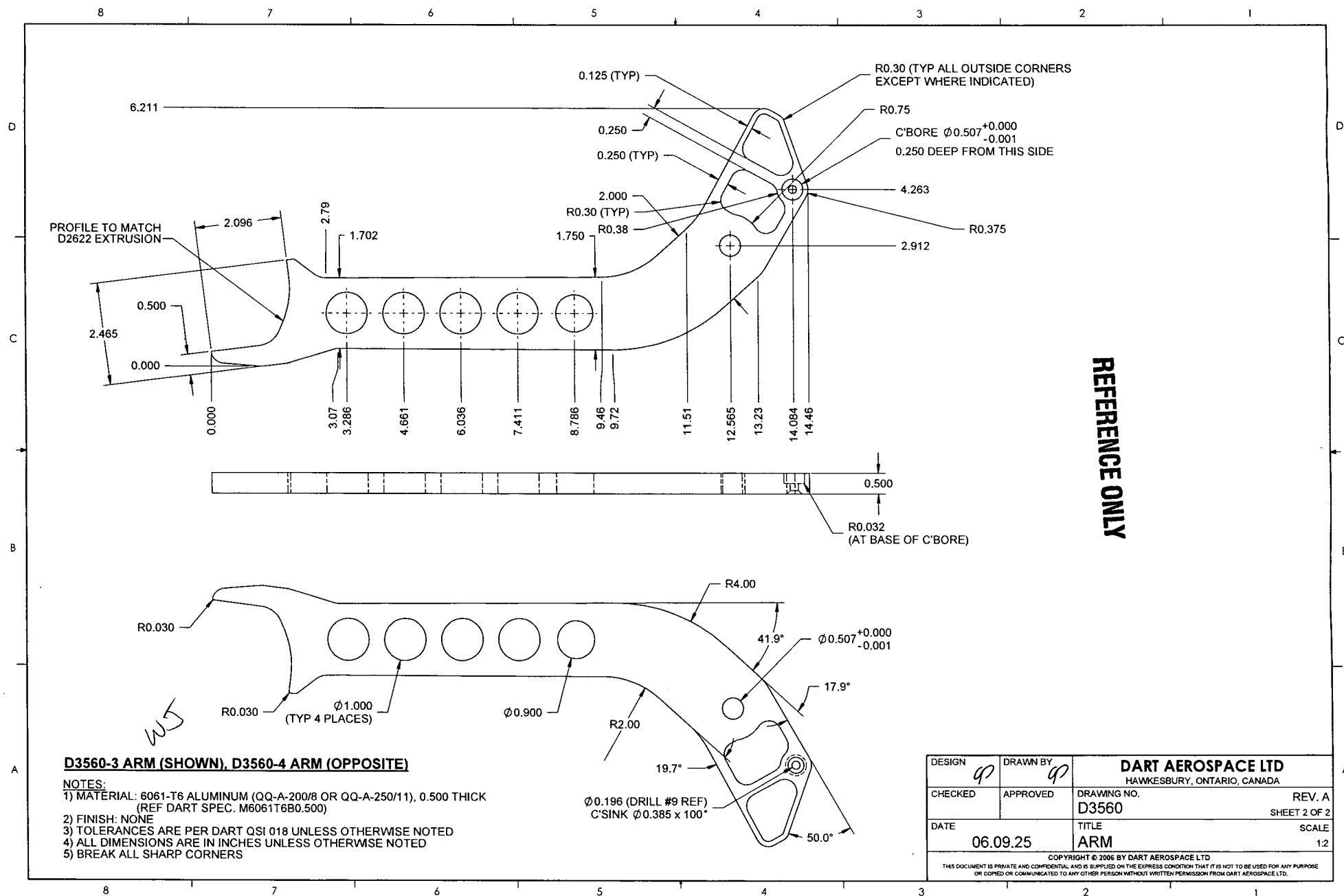
D3560-1/-2/-3/-4 Arm

- new part for D3562-041/-042 step weldment (-033/-034 step kits).
- should be made on waterjet. C'boring, and 0.507 diameter hole should be machined because of need for tight tolerance.

D3562-041/-042 Step Weldment

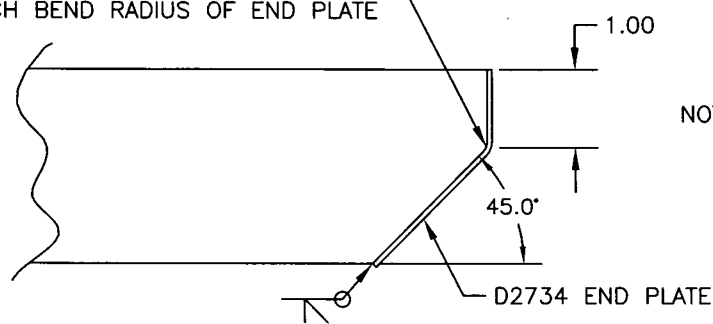
- new part for -033/-034 step kits.
- uses new D3560 arms
- needs special weld jig because arms are mounted at an angle.
- need to make prototype using jig for engineering test fit before making large quantities.





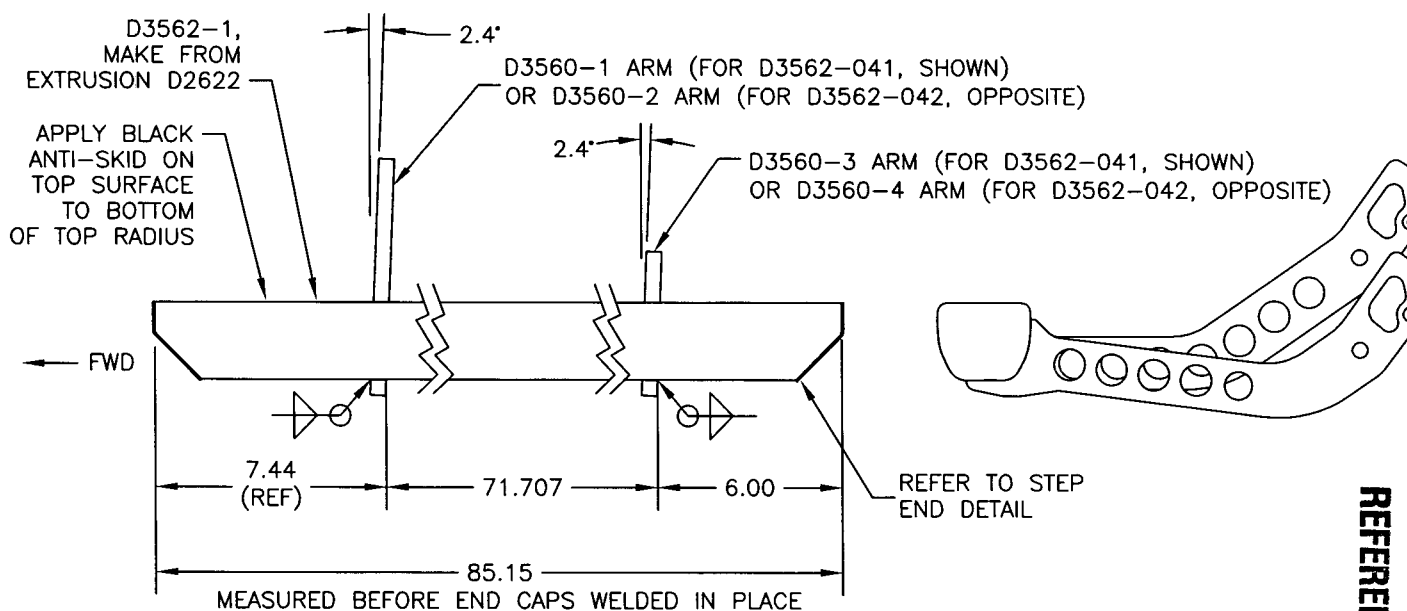


ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

TYPICAL STEP END DETAIL
NOT TO SCALE



REFERENCE ONLY

D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES

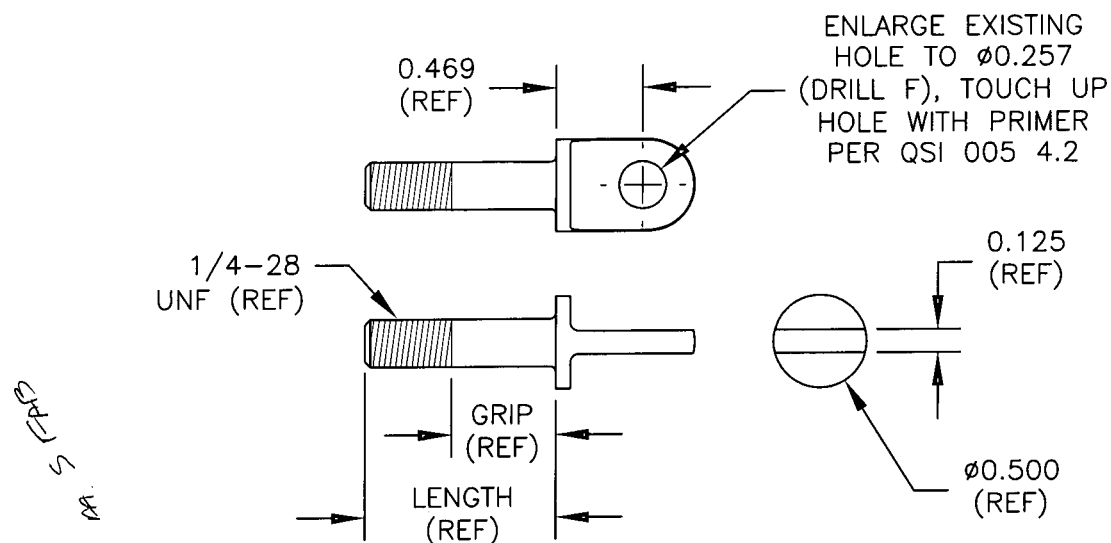
DESIGN	DRAWN BY	DART AEROSPACE LTD
gq	gq	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3562
DATE	TITLE	REV. A
06.09.26	STEP WELDMENT	SHEET 1 OF 1
A	06.09.26	NEW ISSUE
		SCALE
		NTS



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3563	REV. A SHEET 1 OF 1
DATE 06.10.24		TITLE EYEBOLT	SCALE NTS
A	06.10.24	NEW ISSUE	

REFERENCE ONLY

SPECIFICATION CONTROL DRAWING



D3563-X EYEBOLT

- 1) MAKE FROM: AN43B-XA EYEBOLT, CAD PLATED STEEL WITH UNDRILLED SHANK
- 2) SPECIFICATION: D3563-X EYEBOLT

WHERE 'X' IS DASH NUMBER OF AN43B EYEBOLT PER MIL SPEC 'AN42 THRU AN49'. FOR EXAMPLE:

PART NUMBER	MAKE FROM	LENGTH (REF)	GRIP (REF)
D3563-4	AN43B-4A	0.531	0.063
D3563-5	AN43B-5A ✓	0.656	0.188
D3563-6	AN43B-6A	0.781	0.313
D3563-7	AN43B-7A ✓	0.906	0.438
D3563-10	AN43B-10A ✓	1.031	0.563
D3563-11	AN43B-11A	1.156	0.688
D3563-12	AN43B-12A	1.281	0.813

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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D412-630-013/-014 Heli-Access-Step™ Installation

FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)

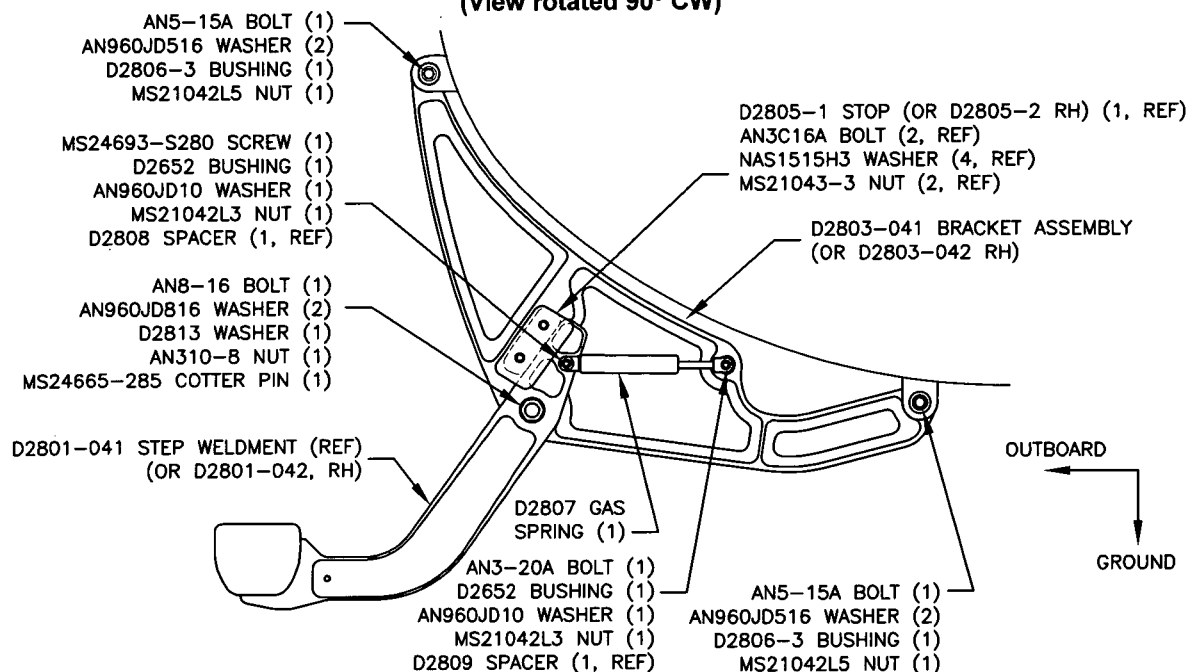
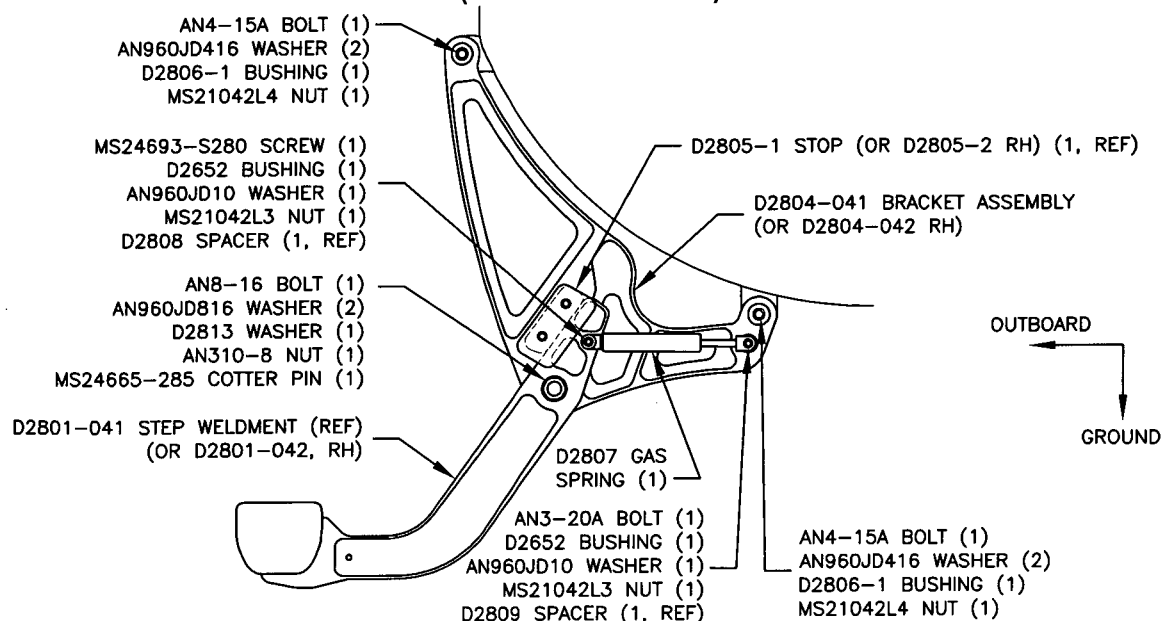
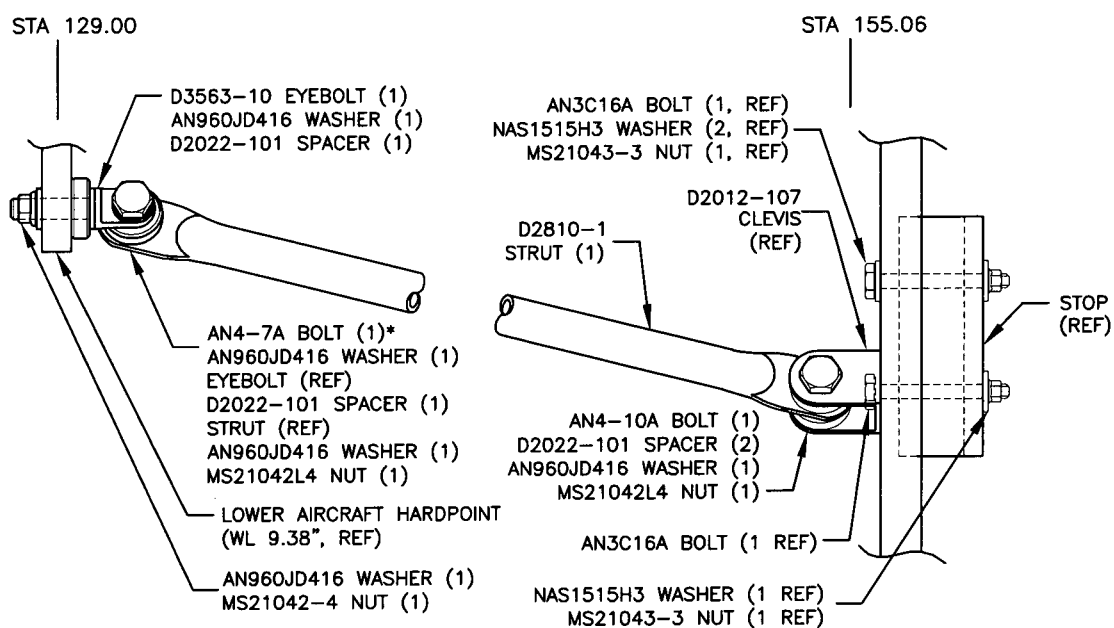


FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)



REFERENCE ONLY

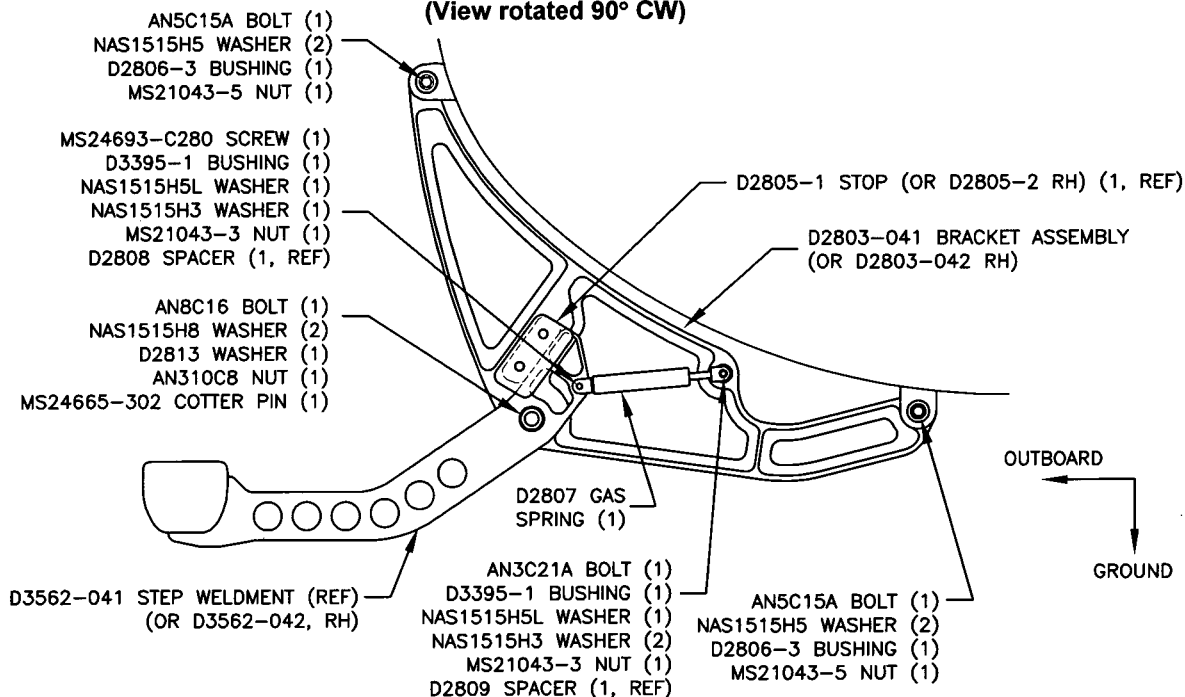
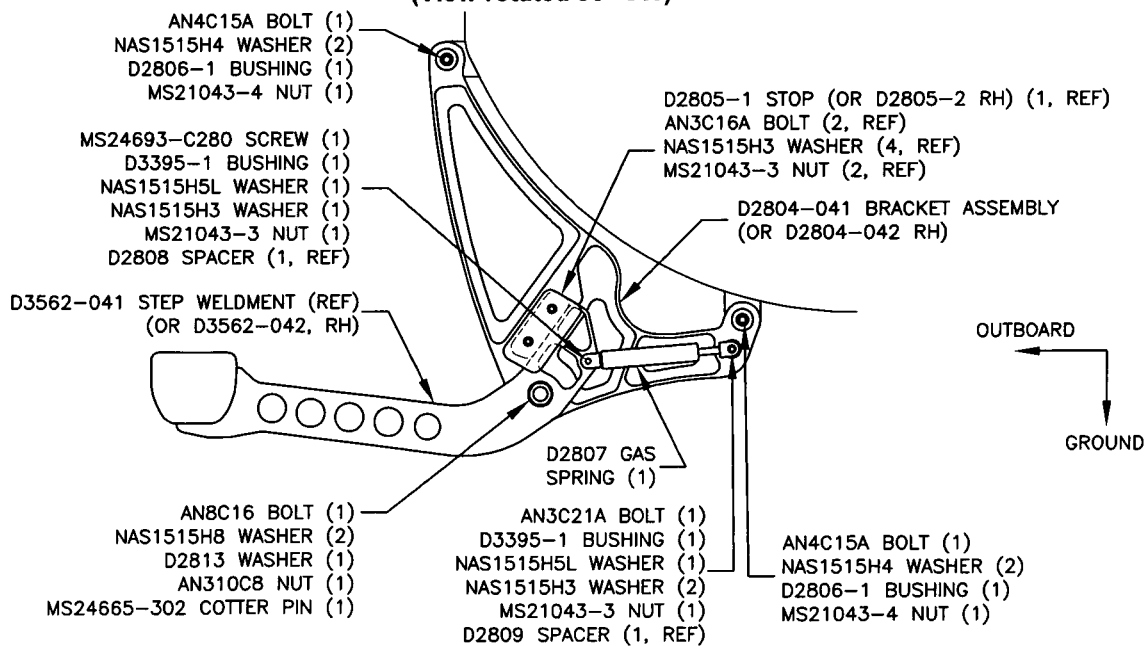
FIGURE 10 – Strut Detail for D412-630-013/-014 *Heli-Access-Step*™ Installation
(NOT TO SCALE)

* IF ADJUSTMENT OF THE STRUT IS REQUIRED TO AVOID OTHER HARDWARE ON THE AIRCRAFT, IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND ADDITIONAL WASHERS AS REQUIRED TO ADJUST THE ATTACHMENT OF THE D2810-1 STRUT TO THE EYEBOLT.

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Revision: **K**
Date: 06.10.05

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

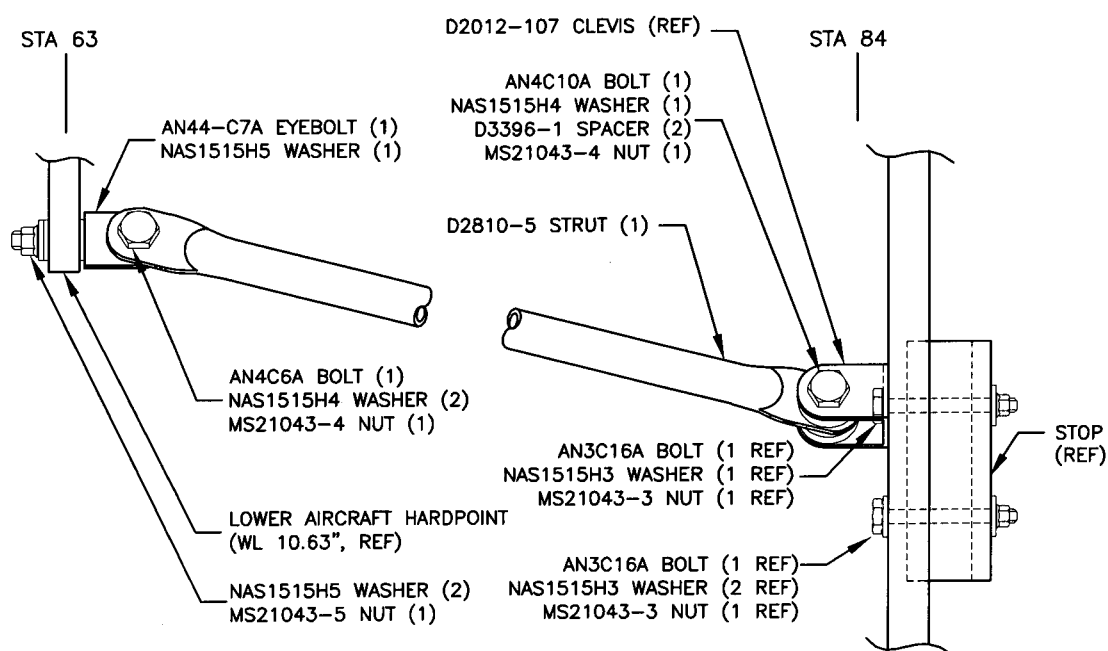
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Revision: **K**
Date: 06.10.05

REFERENCE ONLY

FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step*™ Installation
(NOT TO SCALE)



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Revision: K
Date: 06.10.05

Qty -013	Qty -014	Qty -043	Qty -044	Part Number	Description
X				D412-630-013	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-014	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-043	STEP ASSEMBLY LH
	1		X	D412-630-044	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
2	2	2	2	D2022-101	SPACER
		4	4	D2652	BUSHING
		1		D2801-041	STEP WELDMENT LH
			1	D2801-042	STEP WELDMENT RH
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807	GAS SPRING
		1	1	D2810-1	STRUT
		2	2	D2813	WASHER
1	1			D3563-10	EYEBOLT
		2	2	AN3-20A	BOLT
1	1			AN4-7A	BOLT
		1	1	AN4-10A	BOLT
2	2			AN4-15A	BOLT
2	2			AN5-15A	BOLT
		2	2	AN8-16	BOLT
		2	2	AN310-8	NUT
		2	2	MS24665-285	COTTER PIN (OR AN380-3-4)
		4	4	AN960JD10	WASHER
8	8	1	1	AN960JD416	WASHER
4	4			AN960JD516	WASHER
		4	4	AN960JD816	WASHER
		4	4	MS21042L3	NUT (OR MS21042-3)
4	4	1	1	MS21042L4	NUT (OR MS21042-4)
2	2			MS21042L5	NUT (OR MS21042-5)
		2	2	MS24693-S280	SCREW (OR MS24694-565)

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Revision: K
Date: 06.10.05

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807	GAS SPRING
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A ✓	BOLT
1	1			AN4C6A ✓	BOLT
1	1			AN4C10A ✓	BOLT
2	2			AN4C15A ✓	BOLT
1	1			AN44-C7A ✓	EYEBOLT
2	2			AN5C15A ✓	BOLT
		2	2	AN8C16 ✓	BOLT
		2	2	AN310C8 ✓	NUT
		2	2	MS24665-302 ✓	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280 ✓	SCREW (OR MS24694-C565)

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Revision: **K**
Date: 06.10.05

REFERENCE ONLY

06.10.25

-Feedback from Arrow Aviation & Airlog indicated that the D412-630-023/-024 step can contact the Apical float covers.

-The a/c at Arrow was at 7915# a/c weight +2300# of fuel = 10215# total. At that weight spread was 111.75" FWD and 114.5" AFT.

-Apical indicated that there can be variation in how the bags are packed, they can sometimes be fairly tall but tend to settle over time. 12.38" was determined to be the maximum height from the top of the skidtube the cover would be. Apical so no issue with the step contacting the cover

-Dart has no issue with the step contacting the cover, however it was decided to raise the step to avoid contact to satisfy customer concerns. Airlog indicated that the contact was not acceptable to them.

-At GW it was calculated by CP that the gear would raise another 1". The step was raised to clear $12.38" + 1" = 13.38"$ at a location just forward of the fwd ground handling lug. It should be noted that considering max spread limits and slippery landing surfaces it may still be possible for the step to contact, but as redesigned most scenarios should be fine. Ultimately the step can't be raised too high because it still needs to provide comfortable access.

-The step was made parallel to the skidtubes instead of floor. This reduces the height of the forward portion of the step. Forward and aft step arms now have different geometry.

-New Arm p/ns created for arms and step weldment. D412-630-033/-034 kits created.

-Using a fish-scale, CP measured 16 lbs as the force to req'd raise a -024 step by lifting on the step extrusion. For the step at the new height, the force was 15.5 lbs.

-QR-D412-630-2 created to show changed are acceptable and do not impact the substantiation of the existing steps.

-Dwg D3560 created for new step arms, D3562 created for new step weldment. D3563 created for eyebolt (AN43B eyebolt drilled to accept $\frac{1}{4}"$ bolt).

REFERENCE ONLY

Further to original feedback from Arrow Aviation, feedback from Aero Facility Co., Ltd indicated that the Japanese Coast Guard had several fitting issues regarding installation of the D412-630-013 and D412-630-014 Heli-Access-Steps on their aircraft.

The problems were:

- a) The step was contacting the aircraft when folded upwards.
- b) Interference between the D2804-043/-044 brackets and a hose coupling on their emergency float system.
- c) The D2810-1 strut was contacting some stainless steel conduit for the emergency float system on some aircraft. On the remaining aircraft the strut was very close.
- d) Wording in the installation instructions (IIN-D412-630 Rev.J) was not clear as to which hardpoint the D2801-1 strut should connect to.

Dart Aerospace Ltd has made several changes to eliminate these problems. The problems have been solved as follows:

- a) The forward brackets have been changed from D2803-043/-044 to D2803-041/-042 and the aft brackets from D2804-043/-044 to D2804-041/-042. These brackets are designed so the step is further away from the aircraft in the folded position and there is no longer any possibility of contacting the aircraft when folded. The D2803-041/-042 and D2804-041/-042 brackets are the same part number used successfully on the D412-630-011/-012 and D412-630-023/-024 steps. Additionally these brackets had originally been part of the D412-630-013/-014 steps manufactured prior to the year 2001.
- b) The D2804-041/-042 brackets that are now included in all D412-630-013/-014 kits have had a minor redesign. An additional 3/8" (9mm) of clearance has been provided in the area of the emergency float system coupling, which will eliminate the possibility of contact. This design change is minor: the overall design change has been kept to a minimum, all attaching holes are exactly the same, the altered area of the bracket is as strong or stronger than the previous design, and the bracket is in an area where it will not cause any interference with inflated emergency floats.
- c) The attachment of the D2810-1 strut to the aircraft hardpoint has been changed to an D3563-10 eyebolt (AN43B-10A drilled to accept 1/4" bolt). This will allow the strut to be moved downwards, allowing the strut to clear the emergency float system's conduit.
- d) The installation instructions have been revised with improve the wording. The hardpoint that the D2810-1 strut attaches to is now clearly indicated.

These changes have been incorporated into the latest installation instructions, D412-630 Rev.K. ICA-412-630 also being revised to incorporate changes. Changes to D412-630-013/-014 have been substantiated in QR-D412-630-2.

ENGINEERING CHANGE NOTICE

MPP

DART AEROSPACE LTD		Amendment Design Review (ADR) Yes/No: Yes		ECN #: 865
Date: 06.11.07		ADR Date: 06.09.26		
Job No: 00075		Created By: <i>CP</i>	Checked By:	
Product No: D412-630		Approved By:	Approved By:	
Product Name: Heli-Access-Step		(Proj. Manager)	(Management if reqd)	

Documents Affected:

Release:

-D2804 Rev.C -D412-630 Rev.K
 -D3560 Rev.A -ICA-D412-630 Rev.2
 -D3562 Rev.A -FMS-D412-630 Rev.E
 -D3563 Rev.A

#	Engineering Actions	Yes	No	Responsible	To happen by:	Complete
1	Required Documents/Drawings Under Review?	X		CP		06.11.07 <i>CP</i>
2	Update Blue/Pink Folder/Electronic File	X		KJ		
3	Update DSI Folder/Electronic File		X			
4	Update D-Part Master Binder	X		KJ		
5	Update Grey Project Binder	X		CP		06.11.07 <i>CP</i>
6	Update DEO/DSI Binder		X			
7	Update Master Document List (MDL)	X		CP		
8	Update Document Record (DR)	X		CP		
9	Update Change Record Form	X		CP		06.11.07 <i>CP</i>
10	Move Electronic File	X		KJ		
11	Notify TC of Change	X		KJ/DS		
12	Notify FAA of Change		X			
13	Update QSI 021 (TC/FAA STC)		X			
14	Update QSI 036 (K-Kits)		X			
15	Update Accpac Database	X		KJ		06.11.07 <i>KJ</i>
16	Update Access Database	X		KJ		06.11.07 <i>KJ</i>
17	Verification ARC	X		KJ/CP		06.11.07 <i>KJ</i>
18	Update STC Approval List		X			
19	Update Product Development Summary		X			
20	Create/Update COSS (Estimate/BOM)	X		JLM/EC		
21	Create/Update PPP's	X		KJ/CP		
22	Update Paperwork Kits in Production	X		<i>LL KJ</i>		
23	Update Paperwork Kits in Stock	X		LL		
24	Red Tag Stock with old CHG #	X		DT		
25	Rework/Scrap Current Production	X		LL		
26	Rework/Scrap Kits in Stock?	X		LL		
27	Update Qpulse/Laminated Dwgs	X		KJ		
28	Create/Update Controlled PDF Files	X		KJ		
29	Create/Update FAI sheets	X		JLM/EC		
30	Create/Update CNC Programs	X		JLM/EC		
31	Create/Update Tooling	X		JLM/EC		
32	MPP required?		X			
33	Notify Previous Customers	X		DHS		
34	Notify Eurocopter France		X			
35						
36						

*Not reworking - Peasy can sell the old kits to customers w/o lift off. N/A *KJ**

Description / Action:

-D2804-1/-2 has changed, new shape. This should already be reprogrammed as we've made prototypes.
 -D3563-10 Eyebolt is a new part, this is a drilled AN43B-10A eyebolt that will now be included in all D412-630-013/-014 kits

 -D412-630-033/-034 are two new kits at CHG#001. These are meant to replace D412-630-013/-014/-023/-024.
 -D3560-1/-2/-3/-4 Arm are two new parts, for the new -033/-034 steps,
 -D3562-041/-042 Step Weldments are the new step for the -033/-034 steps. special tooling will be needed to weld the arms on at an angle
 -see attached.

ECN Complete: _____ Date: _____